

June-27-12 3:20:05 PM

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/06/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 11/07/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

15.

Approvals: Process Plan: *MLJ*

Date: 12/06/20 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86344

86344

Page 2

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Item ID: D2672

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw 13" X 24", 206

Start Date: 27/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

OK 12/07/16

4

10

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Memo

PP 86341

0.00

Packaging

Packaging

12/14/16 (4)

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/17/18

MF 12-07-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-27-12 3:20:09 PM

Page 1

Work Order ID: 86344

86344

Parent Item: D2672

D2672

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	72.0100	3.6	14.4	④		

MUHMWB10

UHMW 1" Black

**

B12-7-5

Location	Loc Qty	Loc Code
MAT018	48.9	
120972	1	
121346	27.1	
121954	20.8	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

122286

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86344
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		Tape	RT-10
B	12.750	+/-0.030	12.750	✓		"	
C	4.250	+/-0.010	4.253	✓		vern	RT-4
D	2.000	+/-0.030	2.002	✓		"	
E	9.000	+/-0.010	9.000	✓		Tape	RT-10
F	0.375	+/-0.030	.380	✓		vern	RT-4
G	9.000	+/-0.010	9.000	✓		Tape	RT-10
H	Ø0.260	+0.005/-0.000	.260	✓		vern	RT-4
I	Ø0.93	+/-0.030	.930	✓		"	
J	0.300	+0.030/-0.000	.315	✓		dept gage	RT-6
K	0.625	+/-0.030	.623	✓		vern	RT-4
L	0.063 x 45°	+0.030/-0.010	.062	✓		"	
M	0.250	+/-0.010	.242	✓		mic deep	118 120
N	5.500	+/-0.030	5.506	✓		vern	RT-4
O	R0.250	+/-0.030	.250	✓		rad gage	
P	0.200	+/-0.030	.195	✓		dept gage	RT-6
Q	0.25 x 45°	+/-0.030	.267	✓		vern	RT-4
R	0.950	+0.030/-0.010	.948	✓		"	
S	0.375	+/-0.010	.373	✓		"	

Measured by:	KS	Audited by:	amk	Prototype Approval:	N/A
Date:	12 07 13	Date:	12/07/14	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	★

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

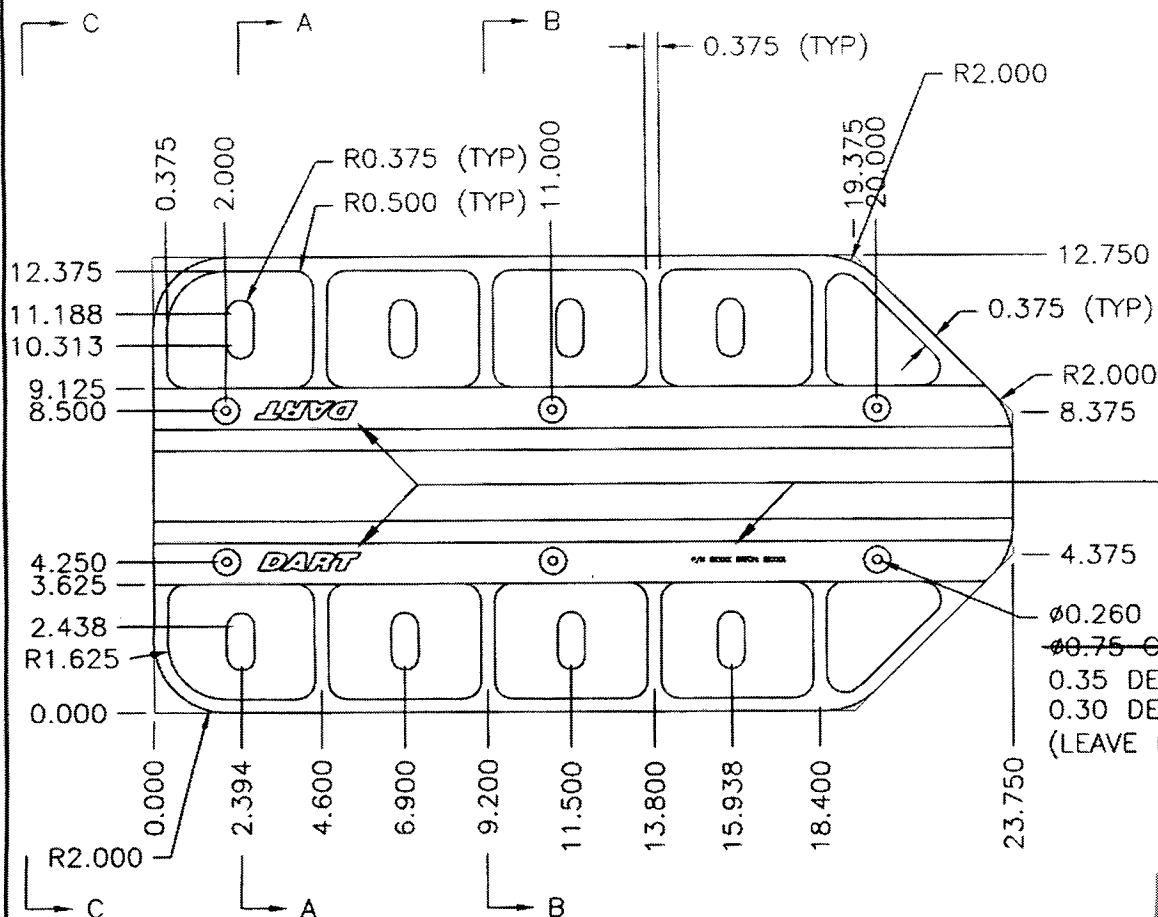
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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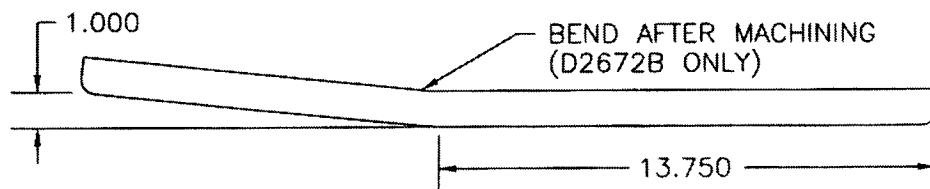
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ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)

$\phi 0.260$ (TYP)
 ~~$\phi 0.75$ C'BORE~~ $\phi 0.93$ C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)

FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

EFFECTIVE	DEOS
9/43	

RELEASED
98.06.17 KS

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE		KE			
CHECKED	APPROVED	DRAWING NO.		REV. B	
KE	KE	D2672		SHEET 1 OF 2	
DATE		TITLE		SCALE	
98.05.19		BEARPAW		1:5	
A	97.04.08	NEW ISSUE			
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			
B1	98.06.17 KS	CHANGE C'BORE, R1.58 WAS R1.50			

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86344 MLC
12/06/28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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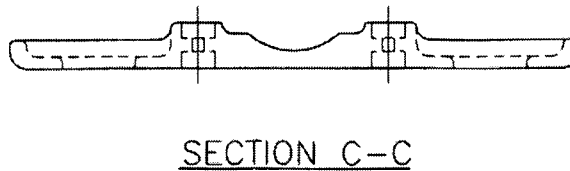
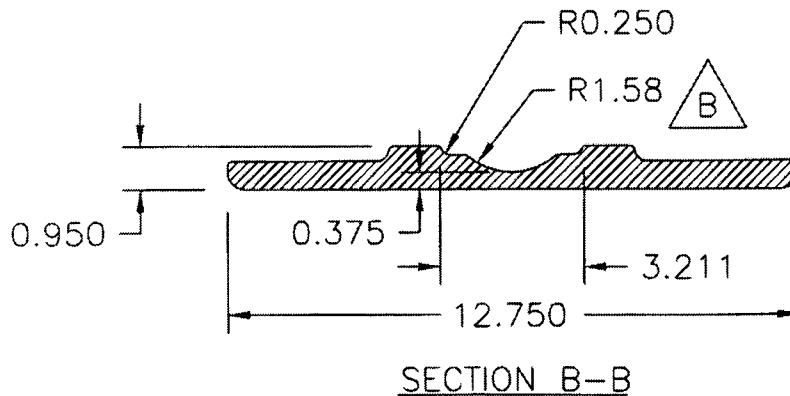
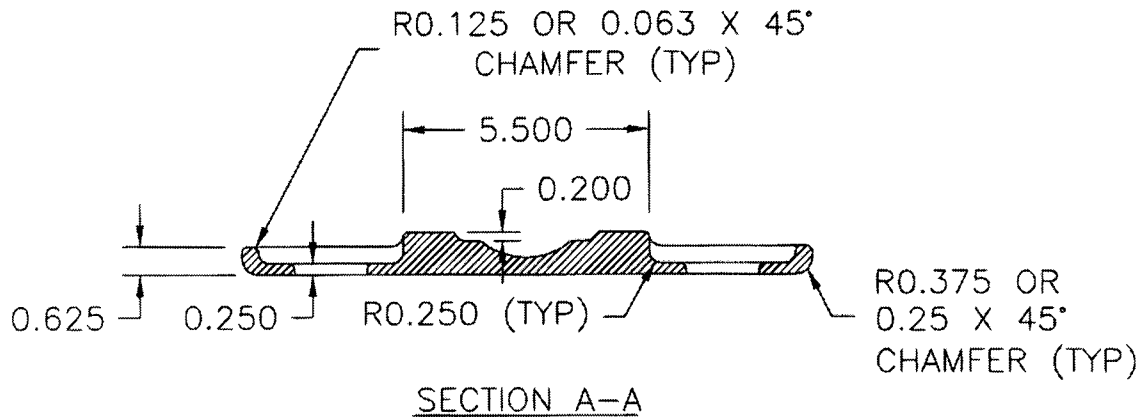
NOTE: Date & initial all entries

86344



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>MM</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
24.06.17 KE



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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